

Date: Tuesday 10/06/2008 12:54:30 PM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : CUP
 Job Number : 39790
 Estimate Number : 12404
 P.O. Number : Part Number : D35031
 This Issue : 10/06/2008 S.O. No. : Drawing Number : D3503 REV A
 Prsht Rev. : NC Project Number : N/A
 First Issue : / / Type : MACHINED PARTS Drawing Revision : A
 Previous Run : 38283 Material :
 Written By : Due Date : 19/06/2008 Qty: 30 Um: Each
 Checked & Approved By : JUL 08.6.10
 Comment : Est Rev:A New Issue 06-05-04 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304R100 304 ROUND BAR



Comment: Qty.: 0.0683 f(s)/Unit Total : 2.0475 f(s)

304 ROUND BAR

(M304R1000)

Batch: M105496

MMP 08/06/12

(31)

2.0 HARDINGE HARDINGE CNC LATHE SMALL



Comment: 1-TURN AS PER FOLIO FA635 & DWG D3503,

FOLIO REV: AA

DWG REV: A

2-DEBURR AS REQUIRED

MMP 08/06/12

(31)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

MMP 08/06/12

(31)

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

5 08/06/13 coaxer (31)

5.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 105

8/6/13

(x31)

SLP

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CUP

Job Number: 39790

Part Number: D35031

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



08/06/16 AJ

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 08.06.16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

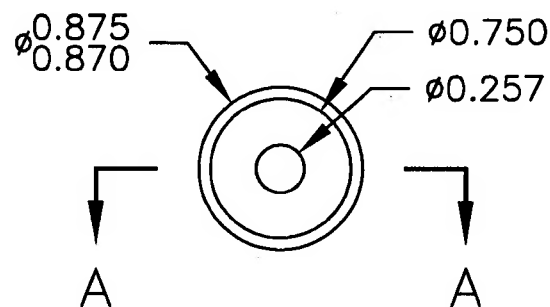
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

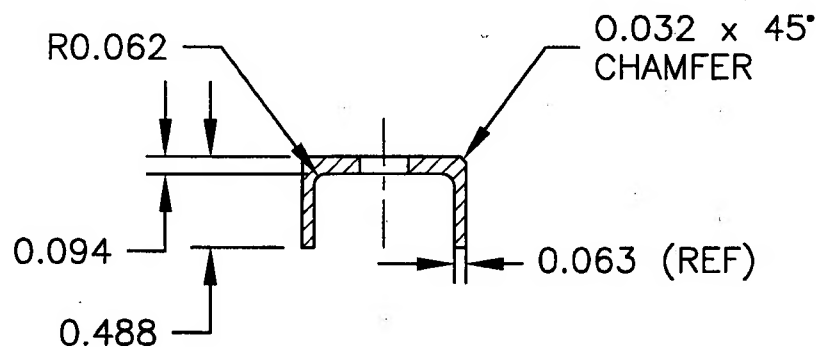
DART

DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3503	REV. A SHEET 1 OF 1
DATE 06.04.19	TITLE CUP		SCALE 1:1
A	06.04.19	NEW ISSUE	

06.04.25 *[Signature]*



D3503-1



SECTION A-A

D3503-1 CUP

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL ROUND BAR
(REF DART MATERIAL SPEC M304RX.XXX)
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK SHARP EDGES 0.005 TO 0.010 MAX

SHOP COPY
RETURN TO
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WITHOUT NOTICE
WORK ORDER
NO. 31790

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